

Work Order ID 83192 -1

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Item ID: D412-698-012

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 13/04/2012 Start Qty: 200

Required Date: 27/04/2012 Req'd Qty: 200

Reference:

Approvals:

Process Plan: M15

QC:

Date: 12/04/13 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

0.00

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Sput

2

2

DAS 16 8-53 12/04/13 JB

DAS 16 8-53 12/04/13 JB

2

12/08/10 JB

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D412-698-012

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

;

: Cabin Door Roller, RH

: 13/04/2012 Start Qty: 2.00

2

Date: 27/04/2012 Req'd Qty: 2.00

2

::

Cust Item ID:

Customer:

Is: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

re ID/
enter ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

40*

Packaging

0.00

ing

Memo

0.00

ng

Identify and pack for shipping as per PPP D412-698-012
Location: _____

QC21- Final Inspection - Work Order Release

0.00

40*

Memo

0.00

ity Control

MCT 12/08/10

MR

12-08-10

Picklist Print

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Work Order ID: 83192

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Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-141

Manufactured No

110

Each

12.0000

6

D3121-141

Bracket Assembly

**

84414 JB

Location

Loc Qty

Loc Code

ST235

12

80097

12

D3121-144

Manufactured No

110

Each

5.0000

2

D3121-144

Bracket Assembly

**

84412 JB

Location

Loc Qty

Loc Code

ST235

4

79311

4

ST235A

1

75032

1

D3137-043

Manufactured No

110

Each

6.0000

2

D3137-043

Bracket Assembly

**

83467 JB 12/08/10

Location

Loc Qty

Loc Code

ST235B

6

79734

6

Picklist Print

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Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

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D412-698-012

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Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3183-044

Manufactured No

110 Each 2.0000

D3183-044

Bracket Assembly

**

B. 85996 SP.

Location

Loc Qty

Loc Code

ST

-4

ST235B

6

75034

2

Manufactured No

110 Each

12.0000

D3199-1

D3199-1

Bracket

**

18

83267

23

Location

Loc Qty

Loc Code

ST236

17

78618

4

79797

8

ST236A

-5

Manufactured No

110 Each

8.0000

D3202-1

D3202-1

Cover

**

2

82663

43 8/12/08/110

Location

Loc Qty

Loc Code

ST241A

8

70294

8

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Shop Packet Print

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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01